

Date: Monday, 6/19/2006 11:28:27 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY  
 Job Number : 27627  
 Estimate Number : 10257  
 P.O. Number : N/A Part Number : D212664201  
 This Issue : 6/19/2006 S.O. No. : N/A Drawing Number : D212-664-241 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : B  
 Previous Run : 26320 Material : N/A  
 Due Date : 7/18/2006 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]* 06.06.19  
 Comment : Est Rev: E 04.02.16 Reformat K/DS  
 Est Rev: F 06-03-29 Remove Coments on Pick List JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG002

KS 06-06-28

2.0 D6006129 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube 23970

Check OD = 3.250"; ID = 2.220"

ML 06/07/04

1

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

ML 06/07/04

1

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

ML 06/07/04

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.11.06	1)	ANGLE OF BEND IS 48° INSTEAD OF 50 <sup>+2°</sup> <sub>-1</sub> . ON ONE SIDE	CP 06.11.06 pvr QSI 042	<del>OK</del> PART IS OK. WITHIN 2° OF NOMINAL	CP 07-01-31	CP 07-01-31	CP 06.11.06 pvr QSI 042	CP 07-01-31

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/01/31

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241. *ML 06/07/04*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*ML 06/07/04*

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*EN 06/07/05 x1*

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube

2-Remove sand and plugs

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

*ML 06/07/04*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

*IT 06 07 07*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*DP 6-7-08*

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

*DP 6-9-21*

W/O:		WORK ORDER CHANGES						
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27627

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



*207-01-11 ①*



Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

*RT 07-01-15*  
*DP/12 07-01-17*  
*DP/507-1-137*

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

*DP/12 07-01-17*

15.0

QC5

INSPECT WORK TO CURRENT STEP



*207-01-18 ①*



Comment: INSPECT WORK TO CURRENT STEP

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: *2890*

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

*C207/01/18 ①*

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

*207/01/19*

18.0

QC6

DIMENSIONAL CHECK

*QC5*



*207-01-22 ①*



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

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## Process Sheet

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Job Number: 27627

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

ML 07 01 24 (1)

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ML 07 01 24 (1)

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

207-01-30 (1)

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.8400 f(s)/Unit Total : 0.8400 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-1009 Abrasion Strip B26650 RT 07-01-30

\*

22.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1 Support B25594 RT 07-01-30

\*

23.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp M10684 RT 07-01-30

\*

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8582

2-Install supports and clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

} RT 07-01-30

W/O:		WORK ORDER CHANGES					
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Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



*207-01-31 ①*



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

27.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Placard  
Batch: *B26018* ✓

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt  
Batch: *M101697* ✓

29.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Bolt  
Batch: *M101418* ✓

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)  
Washer  
Batch: *M102829* ✓

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Nut  
Batch: *M100151* ✓

*207-01-31 ①*

W/O:		WORK ORDER CHANGES						
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/08

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/19/2006 11:28:29 AM  
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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27627

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



PC 7/3/07

Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 7/6/31 (1)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

N/A HAI REV B PC 7/3/07

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten signature

PC 07/03/08

Job Completion



PC 07-0-31

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	27627
<b>Description:</b> Crosstube Assembly (205/212 High Aft)		<b>Part Number:</b>	D212-664-241
<b>Inspection Dwg:</b> D212-664-241 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	0.200	—			
	R0.063	+/-0.010	R0.063	—			
	2.990	+0.005/-0.000	2.991	—			
	5.237	+/-0.030	5.242	—			
	2.600	+0.005/-0.000	2.603	—			
	2.686	+0.005/-0.000	2.689	—			
	2.770	+0.005/-0.000	2.774	—			
	2.854	+0.005/-0.000	2.857	—			
	2.938	+0.005/-0.000	2.940	—			
	3.021	+0.005/-0.000	3.026	—			
	3.133	+0.005/-0.000	3.136	—			
	3.179	+0.005/-0.000	3.182	—			
SIDE B	0.200	+/-0.010	0.200	—			
	R0.063	+/-0.010	R0.063	—			
	2.990	+0.005/-0.000	2.990	—			
	5.237	+/-0.030	5.245	—			
	2.600	+0.005/-0.000	2.602	—			
	2.686	+0.005/-0.000	2.689	—			
	2.770	+0.005/-0.000	2.773	—			
	2.854	+0.005/-0.000	2.857	—			
	2.938	+0.005/-0.000	2.940	—			
	3.021	+0.005/-0.000	3.025	—			
	3.133	+0.005/-0.000	3.136	—			
	3.179	+0.005/-0.000	3.183	—			
	124.36	+/-0.020	124.36	—			

<b>Measured by:</b>	JML	<b>Audited by:</b>	En	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/07/04	<b>Date:</b>	06/07/05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	



DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D212-664-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.06.09 [Signature]

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH =  $124.36 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
FOR AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27627

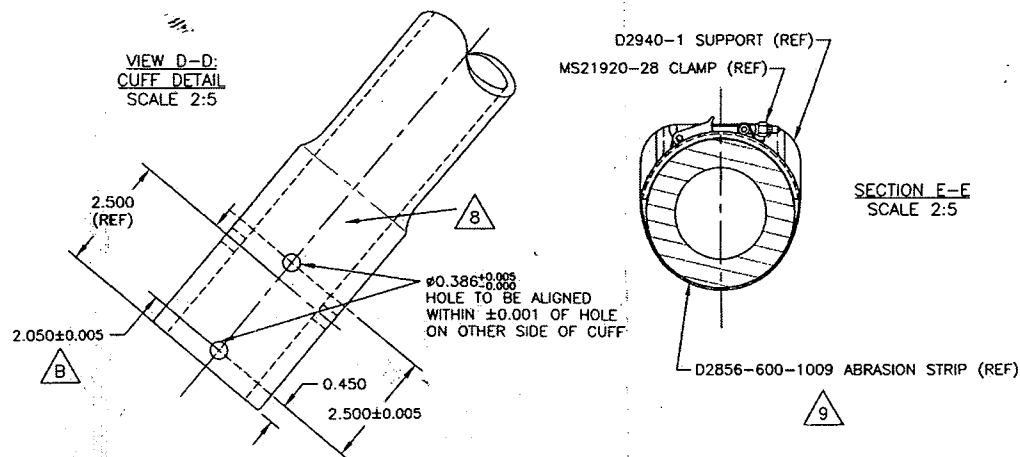
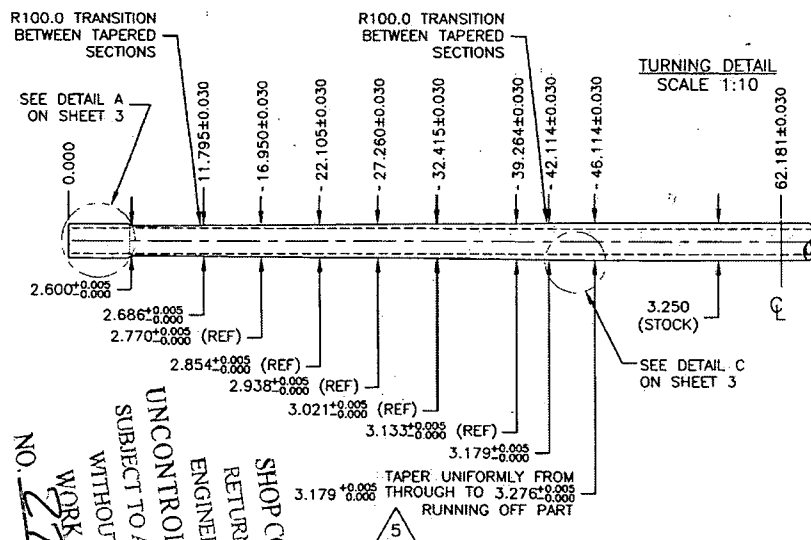
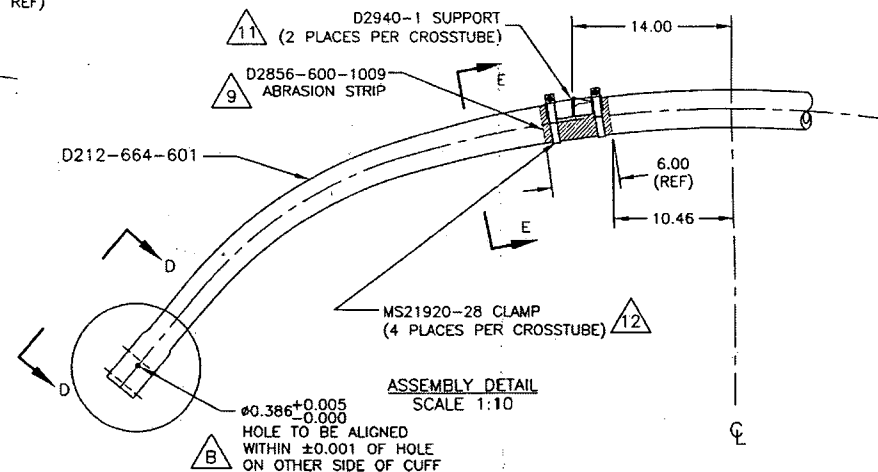
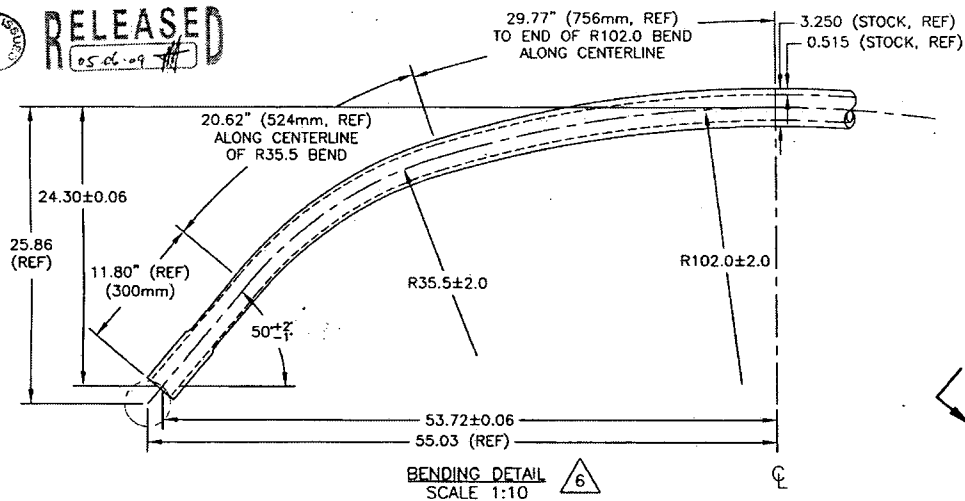
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RELEASED  
05.06.09

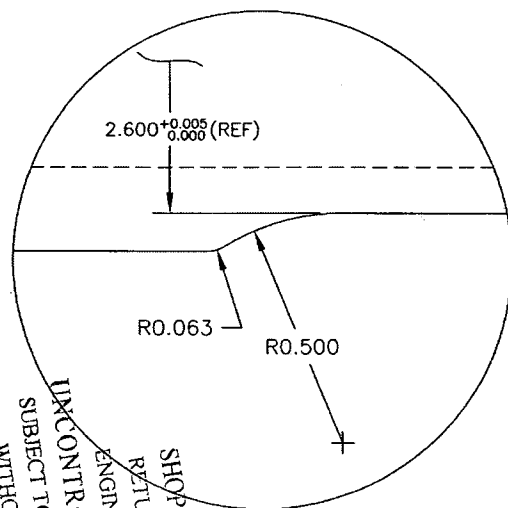
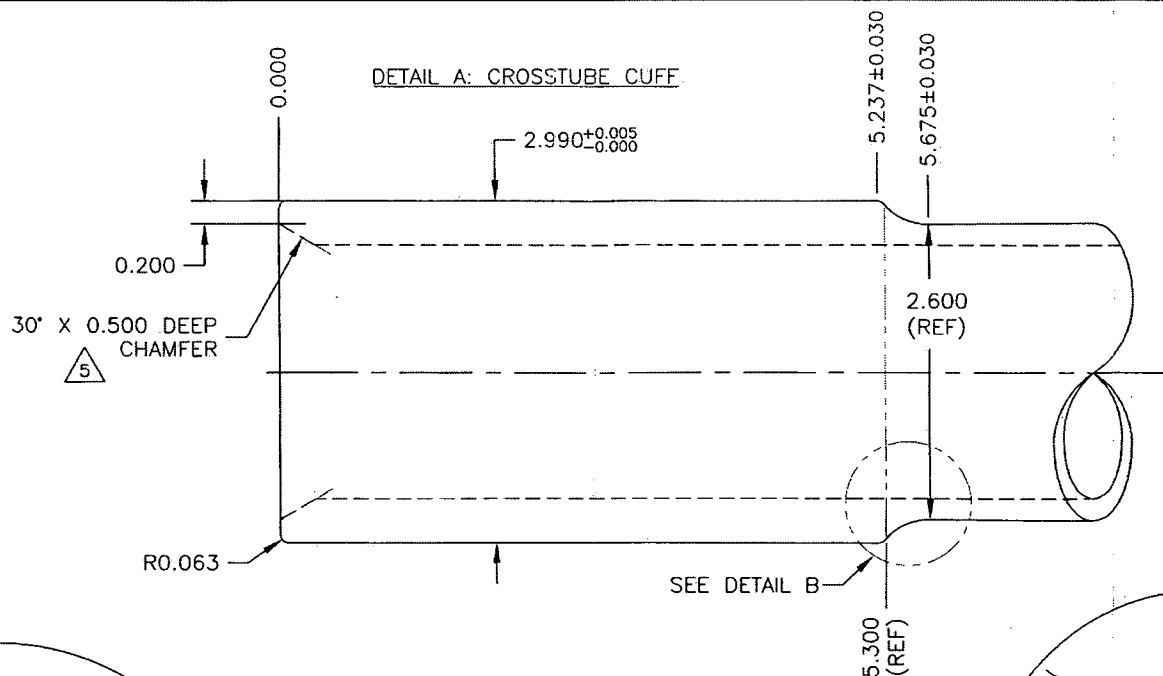


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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	PH	APPROVED	PH		
DATE		05.02.04		DRAWING NO.		D212-664-241	SHEET 2 OF 3
TITLE		CROSSTUBE ASS'Y (205/212 HI AFT)		SCALE		1:10	

NO. 27627  
WORK ORDER  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

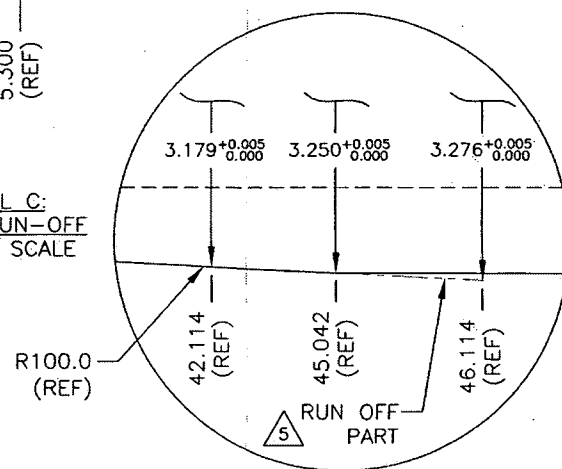


RELEASED  
05-06-09



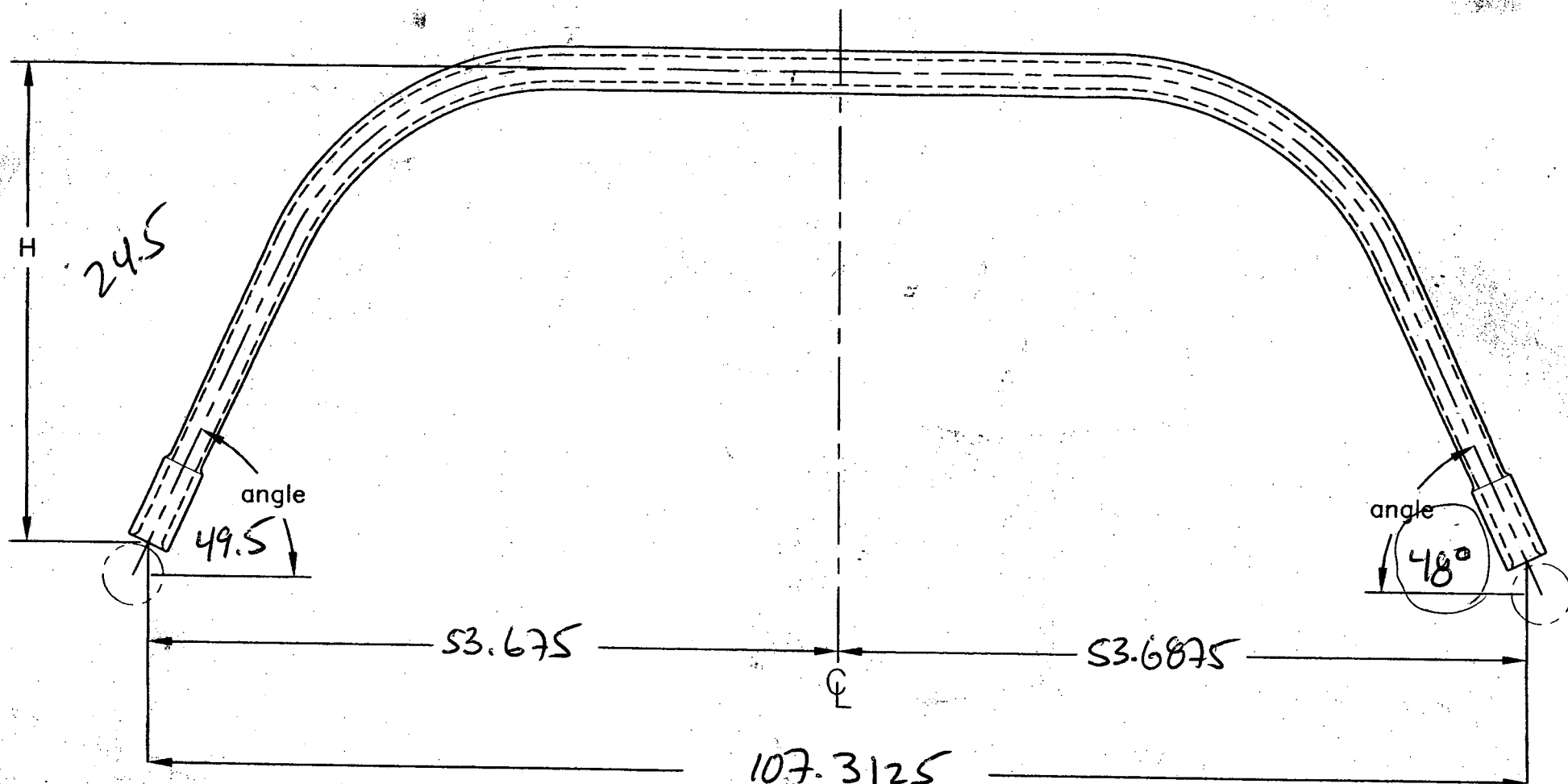
DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



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DATE		05.02.04		DRAWING NO. D212-664-241	REV. B SHEET 3 OF 3
TITLE		CROSSTUBE ASS'Y (205/212 HI AFT)		SCALE 1:1	

NO. 27627  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY



DATE: 06-00-02

DESCRIPTION: D212-664-201

BATCH NO: B27627

DRAWING: D212-664-241 Rev. B

H: 24.30  $\pm$  .06

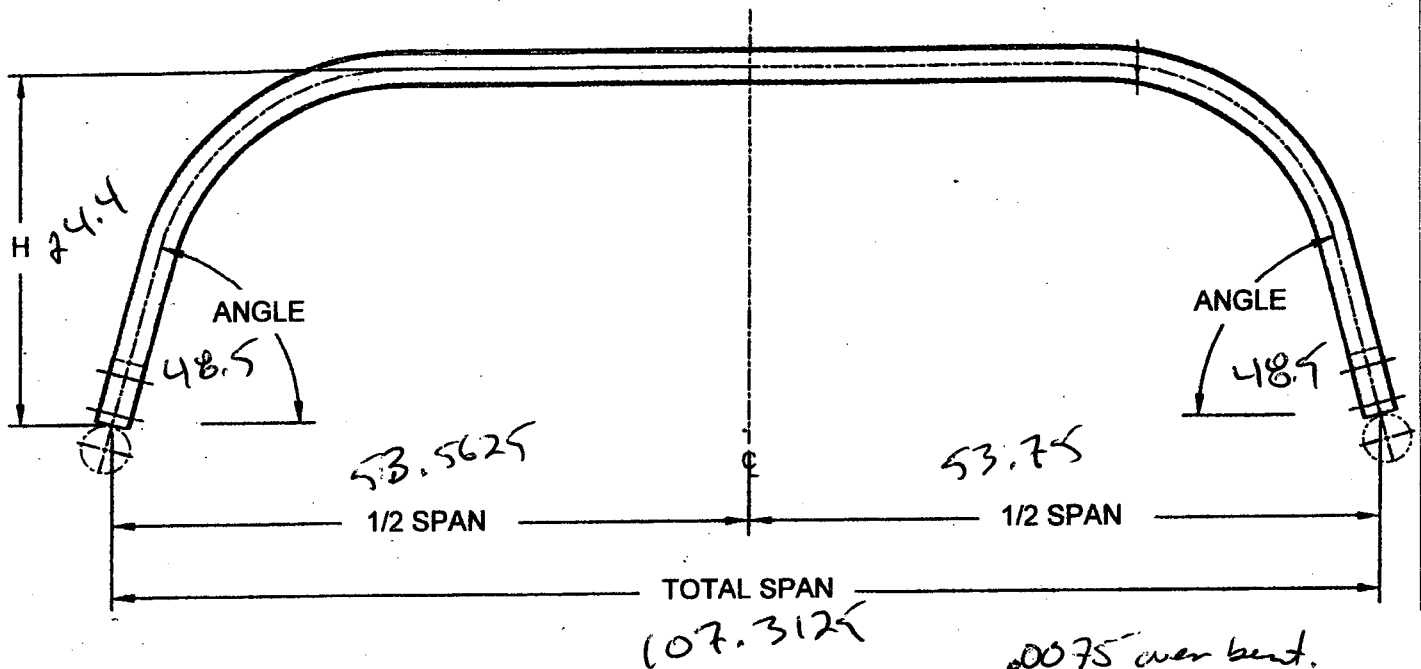
1/2 SPAN: 53.72  $\pm$  .06

TOTAL SPAN: 107.44

ANGLE: 50  $\pm$  1



# Crosstube Bend Dimension Sheet



0075 over bend.  
Fits table very good.

PART NUMBER: D212-664-201

BATCH NUMBER: B27627

DRAWING: 222664-241 REVISION: B

H: 24.3

1/2 SPAN: 53.72

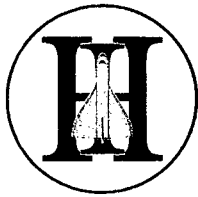
TOTAL SPAN: 107.44

ANGLE: 50°

QC 15: 2

DATE: 07-01-11

QTY: 1



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35593

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (4) P/N D212-664-201 S/N's B28762, B27627, B27990 & B27988

Qty. (1) P/N D206-667-201 S/N B29095

Qty. (1) P/N D206-667-203 S/N B28978

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

Six (6) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE January 18, 2007

INSPECTION  
STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

2890

ADDRESS:

CONTACT NAME:

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

## Material Requisitions

R/S#: \_\_\_\_\_

Part Number: D206-628-034

Batch Number: \_\_\_\_\_

Quantity: \_\_\_\_\_

Required by: \_\_\_\_\_ Date: \_\_\_\_\_

### Used for

Part Number: H41 00002

Batch Number: \_\_\_\_\_

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments: \_\_\_\_\_  
\_\_\_\_\_

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## Material Requisitions

R/S#: \_\_\_\_\_

Part Number: D212-664-401Batch Number: B27625Quantity: 1Required by: AW Date: 07-01-30

### Used for

Part Number: H41 00002

Batch Number: \_\_\_\_\_

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments: \_\_\_\_\_  
\_\_\_\_\_

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## Material Requisitions

R/S#: \_\_\_\_\_

Part Number: D212-664-201Batch Number: B27627Quantity: 1Required by: SW Date: 07-01-31

### Used for

Part Number: H41 00002

Batch Number: \_\_\_\_\_

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments: \_\_\_\_\_  
\_\_\_\_\_

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